

ROYAL 9018 M (E 9018M)

AWS : SFA 5.5, E 9018M

IS : 1395E 63 BG129Fe

Applications

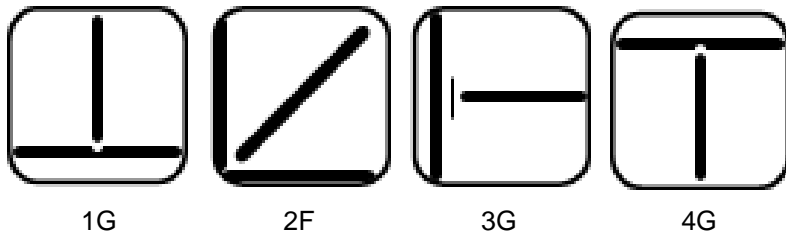
Welding of grain refined steels. Q&T steel, HSLA steel, and ASTM A615 Grade 60 steel, structural fabrication, Penstocks, Tanks, pressure vessels.

Characteristics on Usage

A heavy coated low hydrogen iron powder type electrodes , welding in all positions used for welding steel having high tensile strength upto 70 Kg/mm² as well as low alloy structural steel. The weld is of radiographic like quality having excellent welding characteristics like crack

Notes On Usage

- 1) Dry the electrodes at 350 - 400°C for 60 min before use.
- 2) Keep the arc as short as possible .
- 3) Adopt back step method or strike the arc on a small plate prepared for this particular purpose because ar striking o the base metal is in danger of initing cracking.

Welding Positions**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %
0.10 Max	0.60-1.25	0.80 Max	0.030 Max	0.030 Max	0.15 max	1.40-1.80	0.3

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT – 50 ° C (J)	HARDNESS
620 Min	540 Min	24 % Min	27 Joules Min	200 BHN Max

Approvals**Packing and Welding Current**

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50X350	150	600	AC/DC (+)	70-100
3.15X450	100	400		100-140
4.00X450	70	280		140-180
5.00X450	45	180		180-230